



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5134-042
Job Sheet 173735



Part No: D5134-042

Job Qty: 8 ea

Part Name: Damper Support Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

ob Tracking No:

Due Date: 3/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	3/23/18	3/23/18	0.00	0.00	Start Up Machining-3		SBL 18/06/04
100	Bandsaw	8 pcs	3/23/18	3/23/18	0.00	0.32	Bandsaw1		DASBL 18/06/04
110	CNC Vertical Machining	8 pcs	3/24/18	3/24/18	0.63	18.60	HAAS1-4		57SBL 18/06/06
120	QC	8 pcs	3/24/18	3/24/18	0.00	0.00	QC2 Machining-3		9-89SBL 18/06/04
130	QC	8 pcs	3/24/18	3/24/18	0.00	0.00	QC8 Machining-3		SA 18-06-12
135	HandFinish	8 pcs	3/24/18	3/24/18	0.00	0.67	HandFinish1		SA 18-06-12
137	QC	8 pcs	3/24/18	3/24/18	0.00	0.00	QC7-4		JUN 13 2018
140	SprayPaint	8 pcs	3/24/18	3/24/18	0.00	1.33	Spray Paint		JUN 13/06/2018
150	QC	8 pcs	3/24/18	3/24/18	0.00	0.00	QC14		JUN 16 2018
160	Small Fab	8 pcs	3/26/18	3/26/18	0.00	1.69	Small Fab-8		SMB
170	QC	8 pcs	3/26/18	3/26/18	0.00	0.00	QC5		JUN 21 2018
180	Packaging	8 pcs	3/26/18	3/26/18	0.00	0.00	Packaging3-2	LG054	JUN 21 2018
190	QC21-SA	8 Ea	3/26/18	3/26/18	0.00	0.00	QC21		JUN 21 2018

Part Op 100 - CUT BLANK TO 5.125" LONG

Descriptions: 110 - Mill as per Dwg and folio FB342 DWG REV: B FOLIO REV: AA DEBURR

DAS 21 JUN 21 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B3.000X4.000	7075-T73 Bar 3.0 X 4.0 Grain Direction Along 3"	3.4400 ft (.43 ea)	90-Start up Operation	
NAS77C6-021	Bushing	16 Ea (2 ea)	160-Small Fab	FM134793
140 PRIMER	138847 PAINT 138863			

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B3.000X4.000	3	9	0
160-Small Fab	NAS77C6-021	16	283	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Damper Support, RH	0.360Inches $\pm$ 0.030	0.390 0.330		
2	Damper Support, RH	0.188Inches + 0.005 - 0.001	0.193 0.187		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval

DART AEROSPACE

Container No: S079364

Part: D5134-042

Job No: 173735

Serial No/Batch: S079364

Revision: _____

Inspector: _____

Instructions: _____

Environment ☐

Design ☐

Doc/Data ☐

Equip/Tooling ☐

Handling/Pre ☐

Material ☐

Internal Transport ☐

Tribal Knowledge ☐

LOA ☐

Substation ☐

Past Expiry Date ☐

Misidentified ☐

Cut Too Short ☐
 Instructions Incomplete/Unclear ☐
 Drill Holes ☐

Power Loss/Surge ☐
 Folio/Program ☐
 Grain ☐
 Weld ☐
 Wrong Stock Pulled ☐
 Out of Sequence ☐
 Off-set ☐
 Mislabeled ☐
 Fit/Function ☐
 Misaligned/off center ☐

Positioned Wrong ☐
 Outside Dimensions ☐
 Over/Under tolerance ☐
 Part Incorrect ☐
 Part Lost/Missing ☐
 Part Moved ☐
 Drawing ☐
 Finish ☐
 Misread ☐
 Turning Sequence ☐

3	Damper Support, RH	0.257Inches + 0.006 - 0.001	0.263 0.256	
4	Damper Support, RH	1.932Inches ± 0.010	1.942 1.922	
5	Damper Support, RH	0.632Inches ± 0.010	0.642 0.622	
6	Damper Support, RH	0.632Inches ± 0.010	0.642 0.622	
7	Damper Support, RH	0.730Inches ± 0.010	0.740 0.720	
8	Damper Support, RH	0.500Inches + 0.000 - 0.001	0.500 0.499	
9	Damper Support, RH	0.100Inches ± 0.010	0.110 0.090	
10	Damper Support, RH	0.728Inches ± 0.010	0.738 0.718	
11	Damper Support, RH	0.250Inches ± 0.030	0.280 0.220	Radius
12	Damper Support, RH	0.630Degrees ± 0.030	0.660 0.600	Radius
13	Damper Support, RH	0.063Degrees ± 0.010	0.073 0.053	Radius
14	Damper Support, RH	0.117Inches ± 0.010	0.127 0.107	
15	Damper Support, RH	0.177Inches ± 0.010	0.187 0.167	
16	Damper Support, RH	0.841Inches ± 0.010	0.851 0.831	
17	Damper Support, RH	0.208Inches ± 0.010	0.218 0.198	
18	Damper Support, RH	0Degrees ± 0	0 0	
19	Damper Support, RH	0.860Inches ± 0.010	0.870 0.850	
20	Damper Support, RH	1.471Inches ± 0.010	1.481 1.461	
21	Damper Support, RH	0.130Inches ± 0.030	0.160 0.100	Radius

Plex 3/6/18 1:26 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

